

Work Order ID 75454

75454

Tagh

Page 1 .

Saturday, October 22, 2011 9:45:57 AM

Item ID: D412-785-002-401

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Faceplate

Start Date: 10/24/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/26/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MF* Date: *11-10-22*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D412-785-002-101	B

100 0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg ~~15566~~

Dwg Rev: *B*

Prog Rev: *B*

6061, 6063

2-Deburr as required

1311-10-25

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

1311-10-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75454***75454***

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Tuesday, October 25, 2011 12:54:18 PM

Item ID: D412-785-002-401

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Faceplate

Start Date: 10/24/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/26/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

Quality Control

0.00

130

Small Fab

0.00

130

Small Fab

Memo

Small Fab

Deburr if necessary.
COUNTER SINK AS PER DWG

0.00

140

NC BRAKE

0.00

140

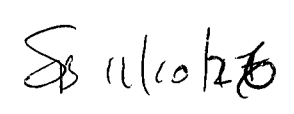
Brake NC

Memo

Brake NC

Bend as per Dwg D412-785-002

0.00



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Weld per dwg A/R Aluminum rod Batch: 114514 0.00

160

Large Fab

Memo

0.00

Large Fab

163

QC9- Inspect visual per QSI004- Fusion Welds 0.00

163

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 10/26/2011 Req'd Qty: 1.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

165

QC5- Inspect part completeness to step on W/O

0.00

165

QC

Memo

0.00

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

175

QC3- Inspect Part Finish

0.00

175

QC

Memo

0.00

Quality Control

1XCM-11/10/26

11/10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Memo

PAG 02

0.00

Packaging

10/27/11

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

11/10/27

11-10-27
Eagly

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Saturday, October 22, 2011 9:45:57 AM

Page 1

Work Order ID: 75454

Parent Item: D412-785-002-401

Start Date: 10/24/2011

Required Date: 10/26/2011

Parent Item Name: Faceplate

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-08-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No				sf	211.8856		1.4736842			

B11-10-28

Location	Loc Qty	Loc Code
MAT021	211.8855684	
116308	26.9755684	
117285	88.91	
119331	96	

116308

1

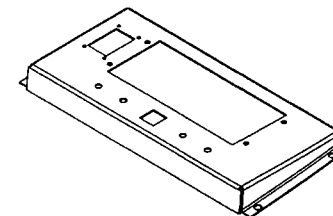
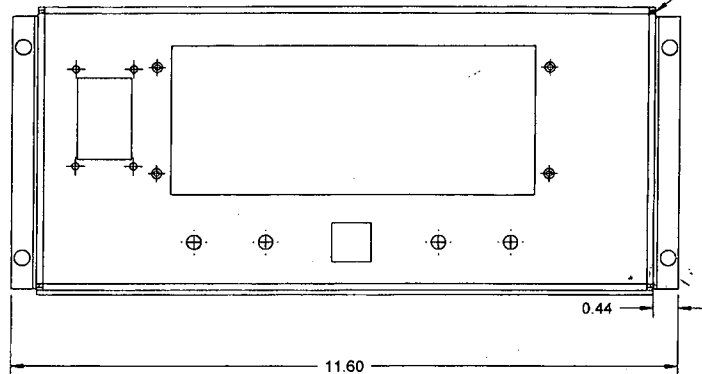
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

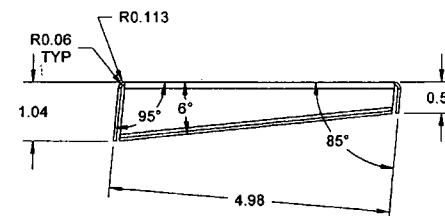
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



75454



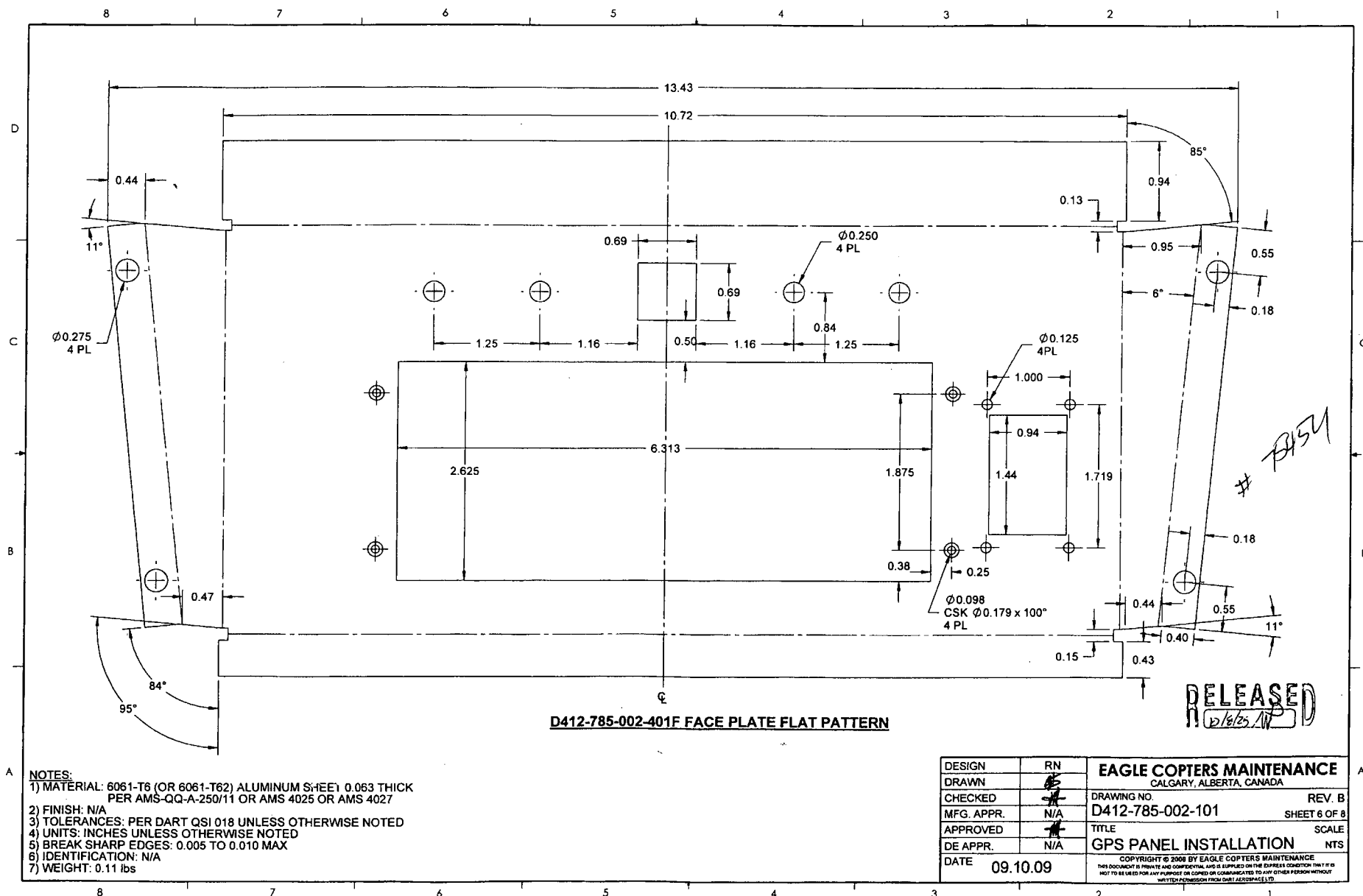
D412-785-002-401 FACE PLATE
MADE FROM D412-785-002-401F

RELEASED
10/16/25 WDD

NOTES:

- 1) MATERIAL: MADE FROM D412-785-002-401F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs
- 8) WELD PER DART QSI 004

DESIGN	RN	EAGLE COPTERS MAINTENANCE	
DRAWN	AS	CALGARY, ALBERTA, CANADA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-002-101	SHEET 5 OF 8
APPROVED	AS	TITLE	SCALE
DE APPR.	N/A	GPS PANEL INSTALLATION	NTS
DATE	09.10.09	<small>COPYRIGHT © 2008 BY EAGLE COPTERS MAINTENANCE THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



DART AEROSPACE LTD

Work Order: 75454

Description: FACE PLATE

Part Number: D412-785-002-401

Inspection Dwg:

Rev: B

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D412-785-002-401

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.25	+0.04 - .001	1.25	✓		V B02	
Ø .098	+0.04 - .001	.100	✓		V	
Ø .250	+0.05 - .001	.250	✓		V	
1.25	± .030	1.252	✓		V	
1.16	± .030	1.160	✓		V	
.69	± .030	.686	✓		V	
.50	± .030	.501	✓		V	
1.16	± .030	1.160	✓		V	
1.25	± .030	1.250	✓		V	
6.313	± .010	6.308	✓		V	
2.625	± .010	2.623	✓		V	
1.875	± .010	1.880	✓		V	
1.008	± .010	1.004	✓		V	
1.719	± .010	1.719	✓		V	
.94	± .030	.936	✓		V	
1.44	± .030	1.435	✓		V	
Ø .275	+0.06 - .001	.275	✓		V	
10.72	± .030	10.726	✓		PROWSON	
13.43	± .030	13.43	✓		T B07	
.94	± .030	.942	✓		V	
.55	± .030	.549	✓		V	
.18	± .030	.182	✓		V	
.433	± .010	.433	✓		V	
1.063	± .010	1.062	✓		V	
Measured by: B	Audited by: J		Prototype Approval:			
Date: 11-10-85	Date: 11/10/85		Date:			

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

